

Date: Wednesday, 27/08/2008 3:15:35 PM  
 User: Julie Lecocq

## Process Sheet

SPLIT-1

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 41648 -1  
 Estimate Number : 12576  
 P.O. Number :  
 This Issue : 27/08/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : 27/08/2008 Type : LARGE FAB ASSY  
 Previous Run : 41245  
 Drawing Name : STEP WELDMENT  
 Part Number : D3562041  
 Drawing Number : D3562 REV E  
 Project Number : N/A  
 Drawing Revision : E  
 Material :  
 Due Date : 08/09/2008 Qty: 2 Um: Each  
 Written By :  
 Checked & Approved By : JLD 08.8.26  
 Comment : Est Rev:A New Issue 06-11-09 JLM  
 Est rev B ECN 987 07.10.09 EC verified by: DD  
 Est Rev:C ECN1048 07-12-18 DD verified by:ec  
 Est Rev:D 08-07-28 add chemical conversion coat DD  
 verified by:EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Step Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)  
 Qty Part # Description Batch:  
 1 D2622-120C Extrusion 40937

Check Material for any Dents or Defects

SAD 08/08/28 (4)

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2622 extrusion as per Dwg D3562

2-Deburr and bevel ends for welding

SAD 08/08/28 (4)

3.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/08/28 (4)

4.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 08/08/28 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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## Process Sheet

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Drawing Name: STEP WELDMENT

Job Number: 41648

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*JS*



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*08-08-28*

*(X4)*

6.0

D3560041

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

*B40299*

ARM WELDMENT

Batch:

*~~B40299~~ 1 B40299*

*~~B40299~~ 1*

*~~40299~~*

*SAD 08/11/06*

*2*

7.0

D3560043

Arm Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

ARM WELDMENT

Batch:

*~~40299~~*

*B.40300*

*SAD*

*08/11/06*

*2*

8.0

MS20600AD4W5

Blind Rivet



Comment: Qty.: 32.0000 Each(s)/Unit Total: 128.0000 Each(s)

Blind Rivet

batch:

*M108990*

*SAD 08/11/06*

*2*

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Transfer drill Rivet holes as per dwg D3562.

2-Touch-up rivet holes with alodine as per dwg d3562

3-Rivet legs using Magnabond as per dwg D3562.

\*\*\*\*\*Ensure to wipe off any excess magnabond \*\*\*\*\*

A/R

Magnabond 6398

Batch:

*M106695*

*SP*

*08.11.06*

*SAD*

*08/11/06*

*SP*

*~~08/11/06~~*

*2*

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*08/11/06 (124)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP WELDMENT

Job Number: 41648

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2734

Step End Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2734

End Cap

339179

SP 08.11.10

(H)

12.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld end caps as per Dwg D3562& QSI 004. Inspect for foreign objects as per QSI 024.

A/R Aluminum Rod

M104855

SP 08.11.10

P10

2-Grind end cap welds flush as per Dwg D3562

SAD 08.11.10

13.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/11/11

(2)

14.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.11.12

(2)

(P10)

15.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 08/11/12

(2)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M109152

(2X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

8:00  
8:320 OF  
8:30

M-H 08/11/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3562-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: JA Date: 08.11.12  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR: <u>41648</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>08.11.11</u>	<u>12-0</u>	<u>Foreign object found in the step.</u> <u>R.C: Excess magnetism fell off of the rivets.</u>	<u>Q51012</u>	<u>Drill a hole as necessary in the to corner of the end cap to remove foreign object. Do Not Exceed hole size of 250".</u> <u>fill hole with weld per Q51004, i. ground flush.</u>	<u>08.11.12</u>	<u>08.11.12</u>	<u>Q51012</u>	<u>08.11.11</u>

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Drawing Name: STEP WELDMENT

Job Number: 41648

Part Number: D3562041

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk as per Dwg D3562 and QSI 005 4.4

Batch: *m109219*

*FL 08/11/13 (2)*

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*EF 08/11/13 (2)*

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

*GA 08/11/13 (2)*

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*08/11/13*

Job Completion



*MF 08-11-14*

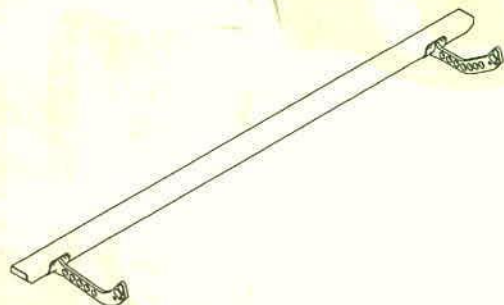
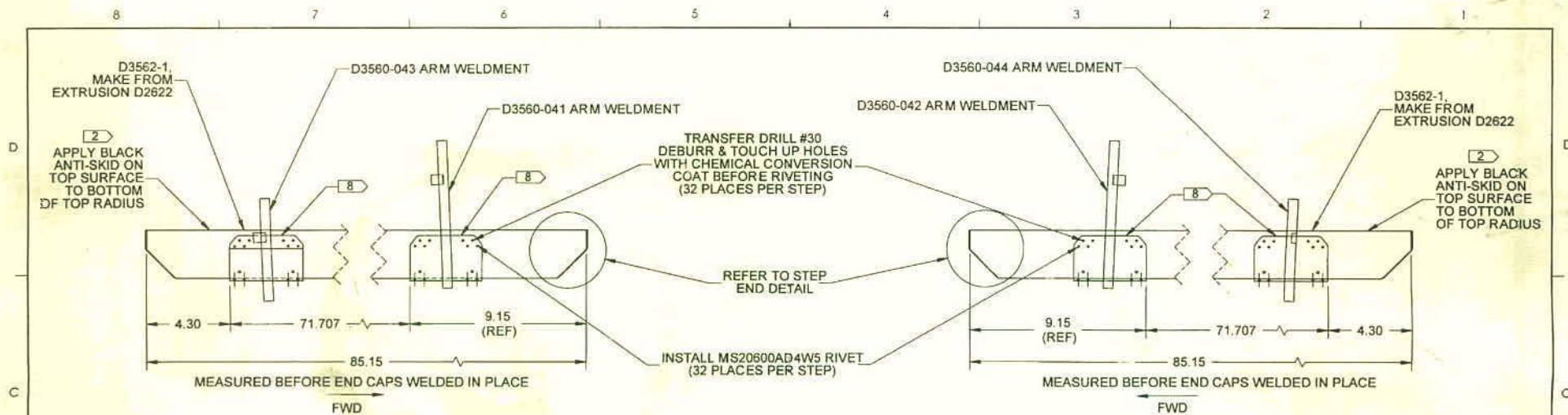
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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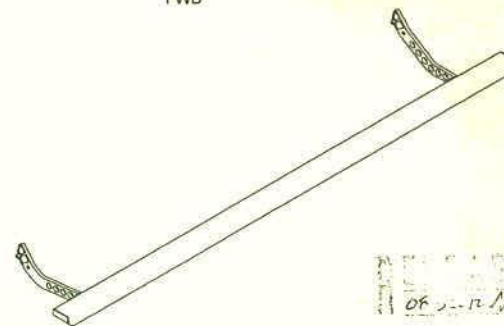
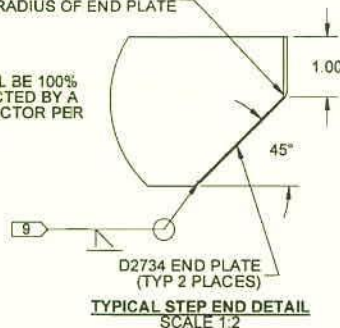
**NOTE:** Date & initial all entries



**D3562-041 LH STEP ASSEMBLY**

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE

NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004



**D3562-042 RH STEP ASSEMBLY**

**NOTES:**

1) MATERIAL: N/A  
2) FINISH:

i) CHEMICAL CONVERSION COAT STEP EXTRUSION PER DART QSI 005 4.1 BEFORE ASSEMBLY

ii) POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

iii) BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 8.79 lbs

8) INSTALL ARM WELDMENTS WITH A LAYER OF MAGNOBOND 6398 BETWEEN THE ARM WELDMENT AND STEP EXTRUSION. FILL ANY TOOLING HOLES WITH MAGNOBOND 6398. CLEAN OFF EXCESS BEFORE POWDER COATING.

9) WELDING: PER DART QSI 004

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3562-041	LH STEP ASSEMBLY
	X	D3562-042	RH STEP ASSEMBLY
1		D3560-041	ARM WELDMENT
	1	D3560-042	ARM WELDMENT
1		D3560-043	ARM WELDMENT
	1	D3560-044	ARM WELDMENT
32	32	MS20600AD4W5	RIVET
2	2	D2734	END PLATE

E	ADD QTY (2) TO D2734 END PLATE ON D3562-042	PH	08.01.11
D	REMOVE D2808 SPACER NOTE; REDRAWN IN SOLIDWORKS	DC	07.11.16
C	NOW MAGNOBOND, ADD D2808, REMOVE 4 RIVETS	CP	07.06.19
B	ARMS NOW RIVETED TO STEP	CP	07.01.15
A	NEW ISSUE	CP	06.09.26
REV.	DESCRIPTION	BY	DATE
DESIGN	gp		
DRAWN	ef		
CHECKED	LE		
MFG. APPR.			
APPROVED			
DE APPR			
DATE	08.01.11		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3562** REV. E  
TITLE **STEP ASSEMBLY** SCALE 1:5

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